

Date: Friday, 6/1/2007 1:02:24 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 32736		
Estimate Number	: 12731		
P.O. Number	: N/A	Part Number	: D353535
This Issue	: 6/1/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3535 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31992	Drawing Revision	: ATB # 07.06.01
		Material	: N/A
Written By	:	Due Date	: 6/8/2007
Checked & Approved By	: <u>07.06.01</u>	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 07-02-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8423 sf(s)/Unit Total: 16.8462 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101873 M103713 (1)

ml 07.06.04

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

SAD 07106105

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

SB 07/06/12

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32736

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*07-06-12 (20)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



*M 101 601*



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*BR*

*07-06-13*

*(20)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M-d*

*07/06/13*

*(20X)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



*(20X)*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP 15*

*M-d 07/06/13*

10.0

QC21

FINAL INSPECTION/W/O RELEASE

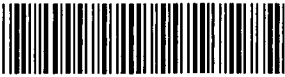


*(20)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/14*

Job Completion



*07-06-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32736
Description: Wearshoe		Part Number: D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓		VERN	
1.885	+/-0.010	1.890	✓		M.T	
6.00	+/-0.030	6.00	✓		M.T	
6.75	+/-0.030	6.75	✓		M.T	
Ø0.188	+0.005/-0.001	0.188	✓		M.T	
23.250	+/-0.010	23.250	✓		M.T	
19.750	+/-0.010	19.750	✓		M.T	
17.750	+/-0.010	17.750	✓		M.T	
14.250	+/-0.010	14.250	✓		M.T	
9.500	+/-0.010	9.500	✓		M.T	
4.750	+/-0.010	4.753	✓		VERN	
0.300	+/-0.010	0.296	✓		VERN	
0.300	+/-0.010	0.297	✓		VERN	
0.038	+/-0.010	0.036	✓		VERN	

Measured by: ml.ml
Date: 07.06.04

Audited by: [Signature]
Date: 07.06.11

Prototype Approval:	N/A
Date:	N/A

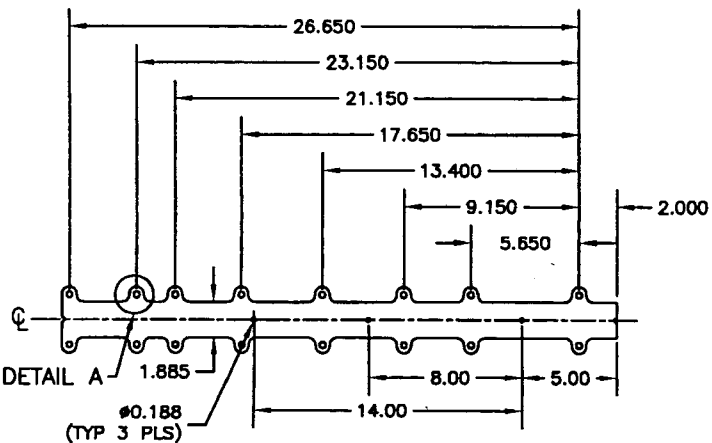
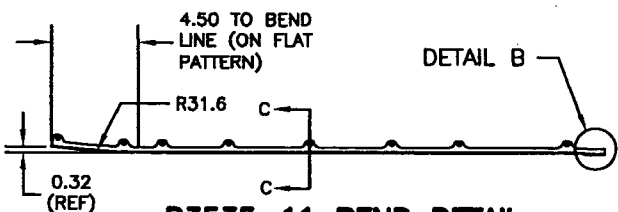
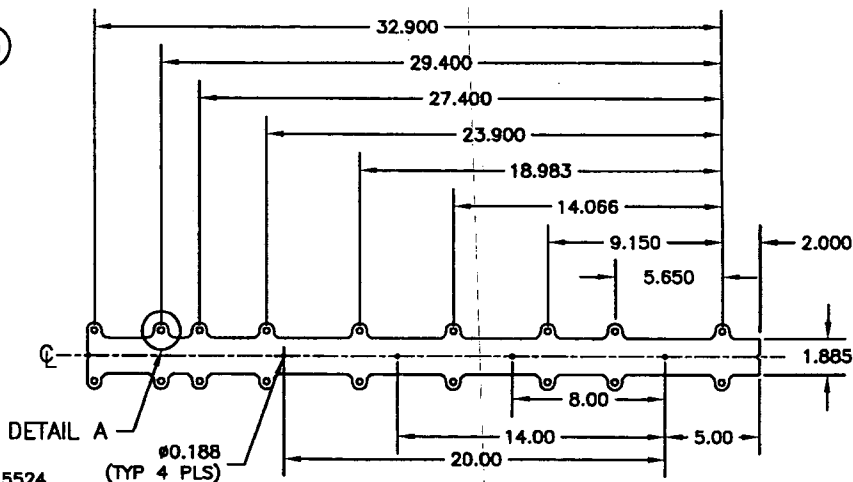
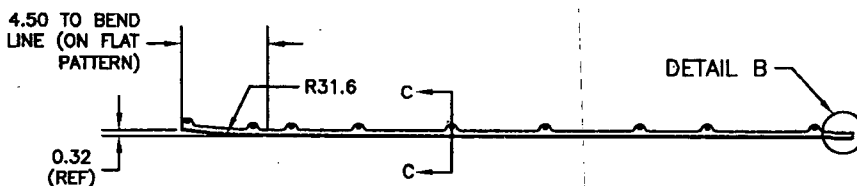
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM [Signature]	[Signature]

**DART**

RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

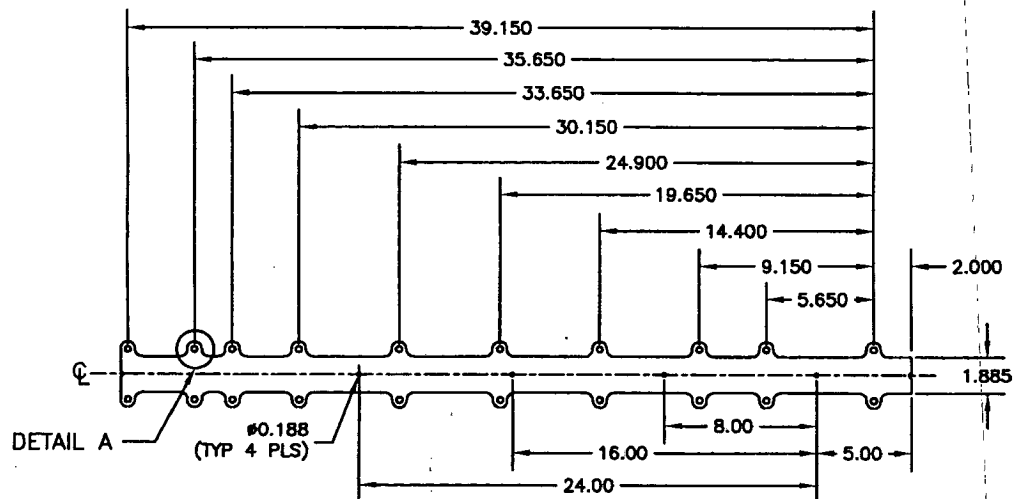
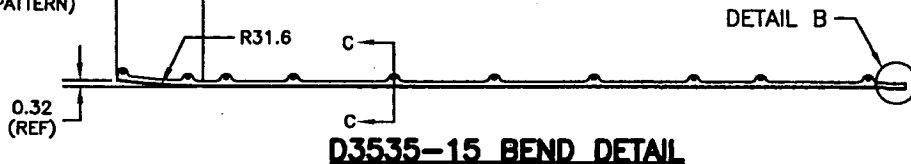
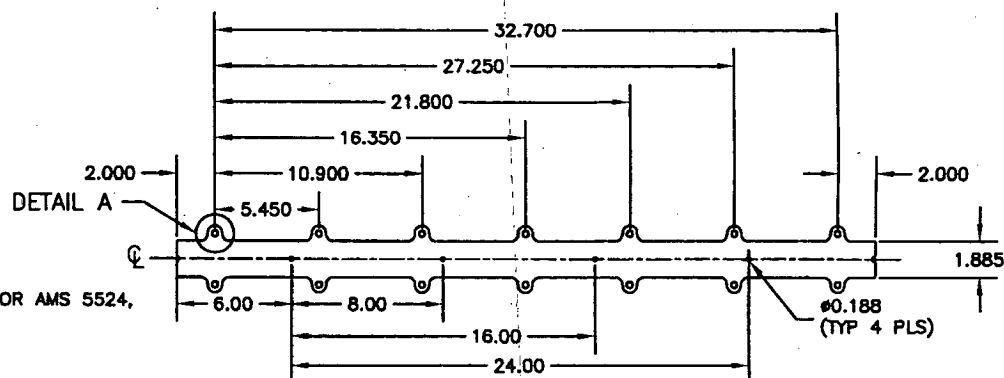
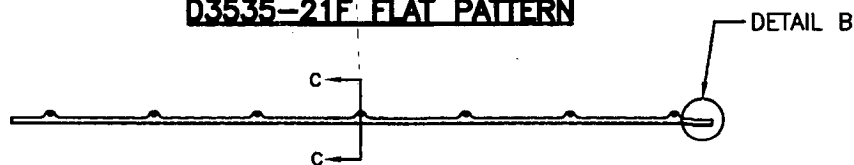
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WITHOUT NOTICE  
WORK ORDER  
NO 32736

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		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

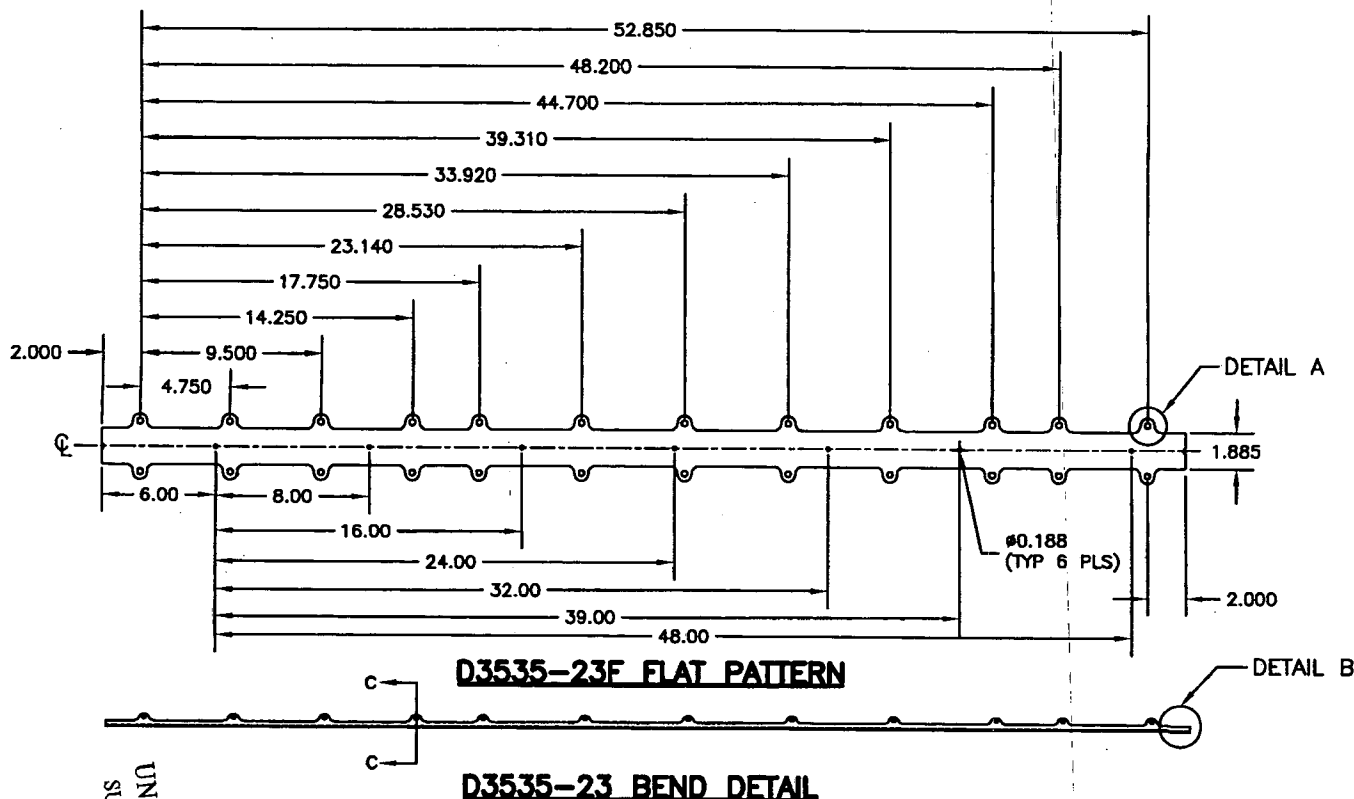
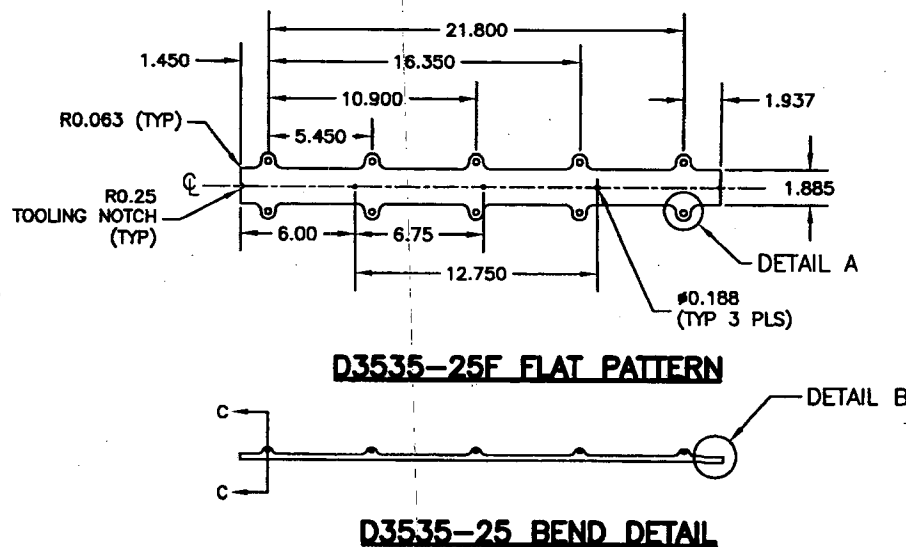
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**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

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**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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CB	PH	PORT HADLOCK, WA
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#	#	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

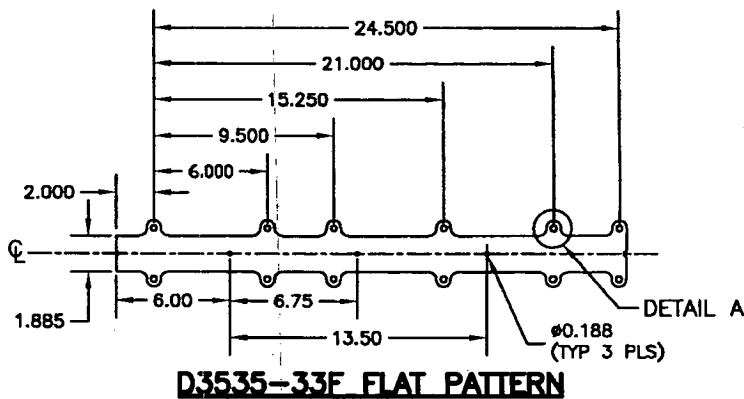
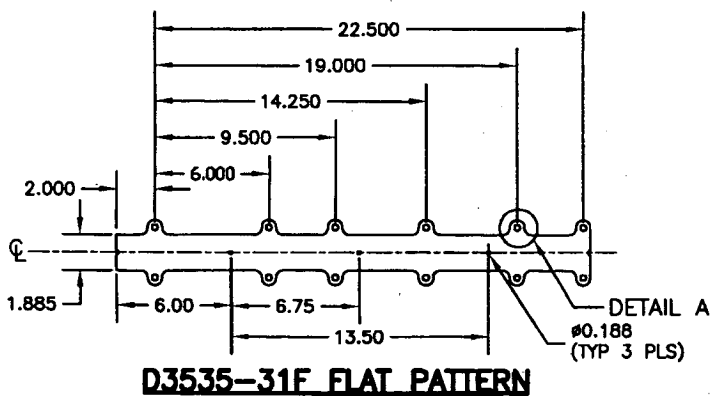


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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
				SCALE 1:10



#### NOTES

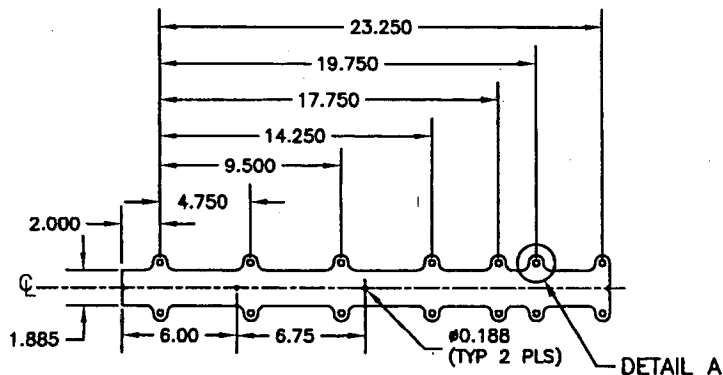
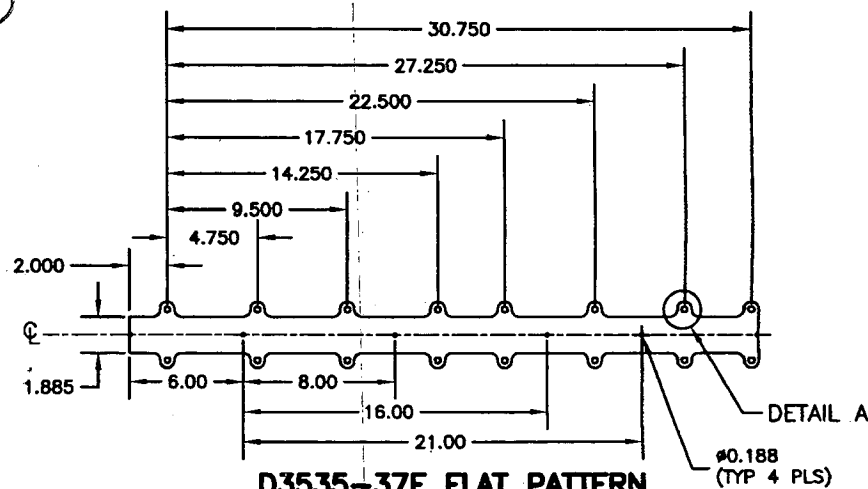
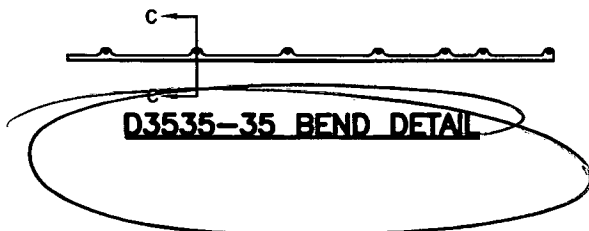
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**D3535-35F FLAT PATTERN****D3535-37F FLAT PATTERN**

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**NOTES**

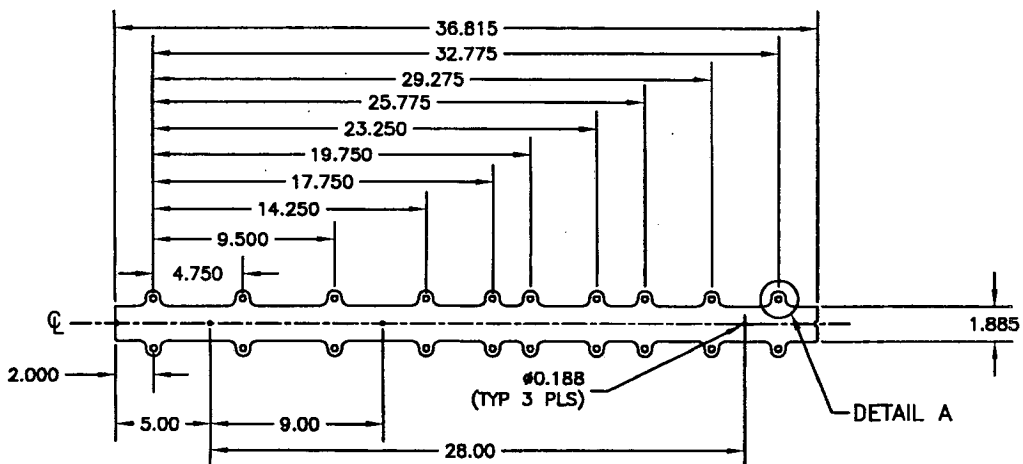
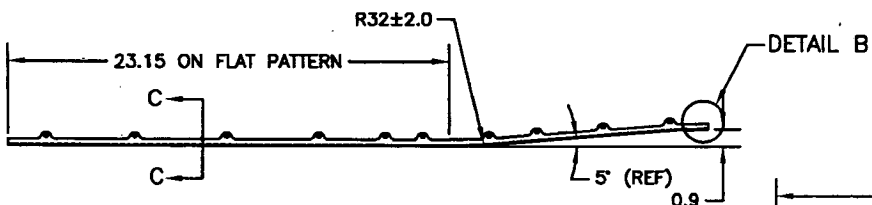
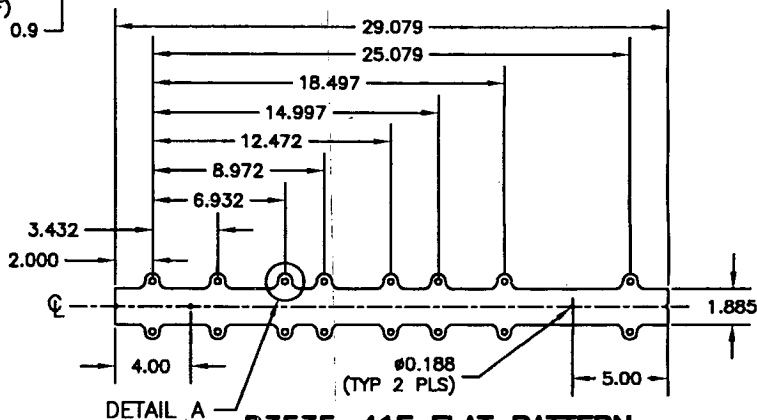
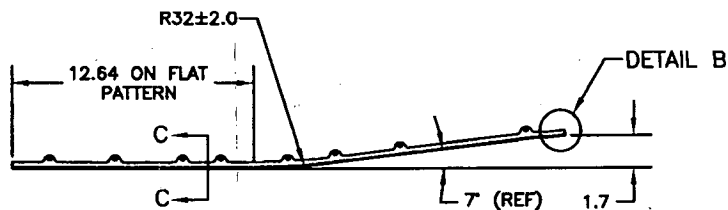
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CB	AT	PORT HADLOCK, WA
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		D3535
DATE	TITLE	SHEET 5 OF 7
07.04.17	WEARSHOE	SCALE 1:10

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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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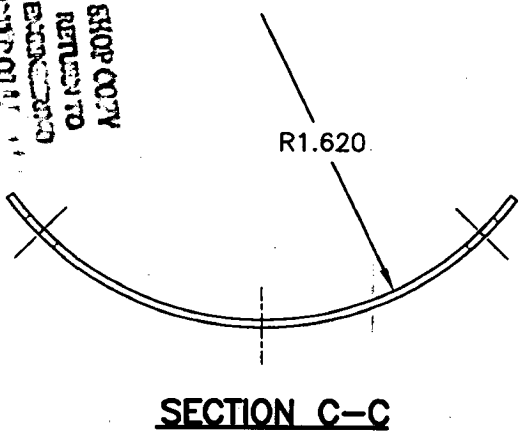
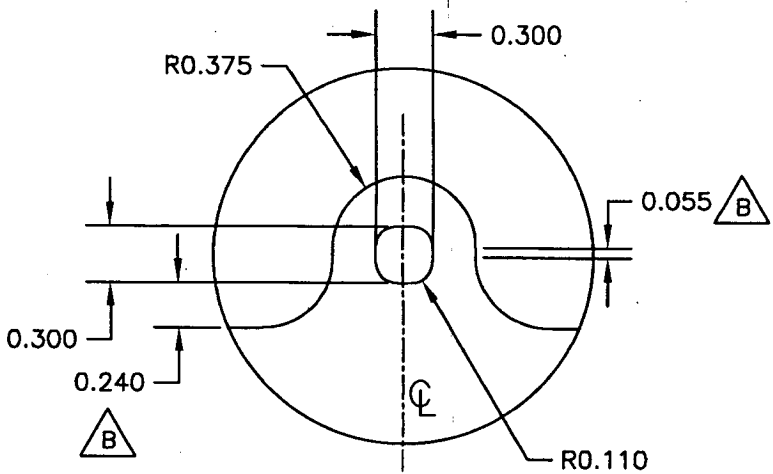
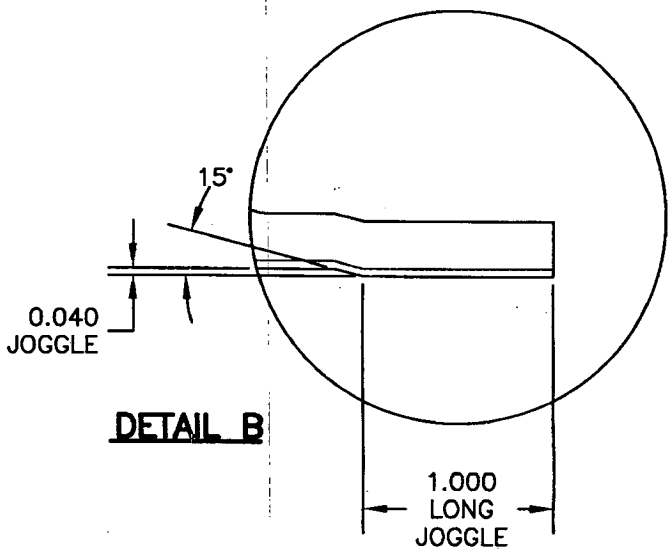
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 6 OF 7
07.04.17	WEARSHOE	SCALE 1:10

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	07.04.17	DRAWING NO.	D3535	SHEET 7 OF 7	
		TITLE	WEARSHOE	SCALE	1:1

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07.04.24



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10.32736

